



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A94-1130-01-27

Job Sheet 171482



Part No: RBE703A94-1130-01-27

Job Qty: 6 ea

Part Name: Tab Adjuster Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 REV K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-1		2-18/03/26
105	Bandsaw	6 pcs	1/25/18	1/25/18	0.00	0.60	Bandsaw1		18/03/26
110	CNC Vertical Machining	6 pcs	1/26/18	1/26/18	0.00	6.00	HAAS1-5		18/03/26
120	QC	6 pcs	1/26/18	1/26/18	0.00	0.00	QC2 Machining-4		18/03/26
130	QC	6 pcs	1/26/18	1/26/18	0.00	0.00	QC8 Machining-4		18-03-27
150	Outsource	6 pcs	2/9/18				ATG001-VC	P0035432	CT 18-3-27
160	Packaging	6 pcs	2/9/18		0.00	0.00	Packaging2		DAS
170	QC	6 pcs	2/9/18		0.00	0.00	QC6		38
180	Packaging	6 pcs	2/9/18		0.00	0.00	Packaging3-1		9-89
190	QC21-SA	6 Ea	2/9/18		0.00	0.00	QC21		DAS 21 9-89

Part Op 105 - Cut blanks at 4.25"

Descriptions: 110 - 1-Machine as per folio FB 582 FOLIO REV: DWG REV: 2-Deburr

3-Engrave T/N number using Marktronic engraver as per DWG.

150 - Issue P/O to ~~480~~ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	2.1000 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X01.500	2	24	0

5052919

Part Specifications

Specifications could not be found.

Plex 2/1/18 2:08 PM Dart.lajeunesse.marie

ML 3-29



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S054878



Part: RBE703A94-1130-01-27

Job No: 171482

Serial No/Batch: S054878

Revision: K

Inspector:

Date: 03/26/18

3.149
1.946

DART AEROSPACE LTD		Work Order:	171482
Description: TAB ADJUSTER BODY		Part Number:	RBE703A94-1130-01-27
Inspection Dwg:	Rev: K	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	±.005	1.252	—		Vern H/108	
2.205	±.005	2.203	—		"	
1.240	±.005	1.259	—		"	
.640	±.005	.640	—		"	
.913	±.005	.913	—		"	
75°	±1/2°	75°	—		C-Square	
Ø.125	±.005	Ø.125	—		Vern H/108	
1.968	±.005	1.968	—		}	
.226	±.005	.224	—			
.945	±.005	.945	—			
30°	±1/2°	30°	—		C-Square	
Ø.6694	±.0016	.610	—		Vern H/108	
2.45	±.010	2.450	—		"	
.472	±.005	.472	—		"	
1.024	±.005	1.024	—		"	
.20X45°	±.010 X ±1/2°	.200X45°	—		"	
.787	±.005	.787	—		"	
2.362	±.005	2.364	—		"	
1.181	±.005	1.182	—		"	
3.94	±.010	3.938	—		"	
Ø.20	±.005	Ø.204	—		"	
Ø.1567	±.0006	Ø.1567	—		"	
.35	±.010	.342	—		"	
.788	±.001	.788	—		"	
.217	±.005	.218	—		"	
R.06	±.010	R.060	—		"	
.236	±.005	.238	—		"	
.472	±.001	.471	—		"	
.40	±.010					

Measured by: <i>gm</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18/03/26	Date: 18/03/27	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

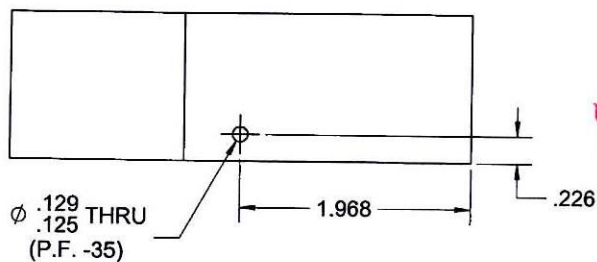
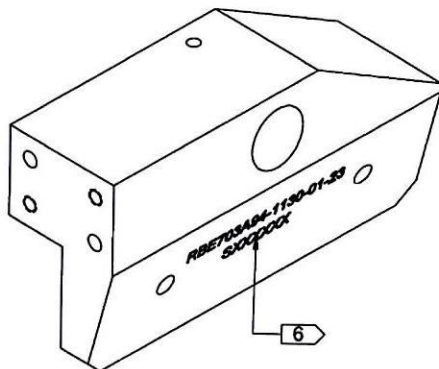


WORK ORDER NON-CONFORMANCE / UPDATE

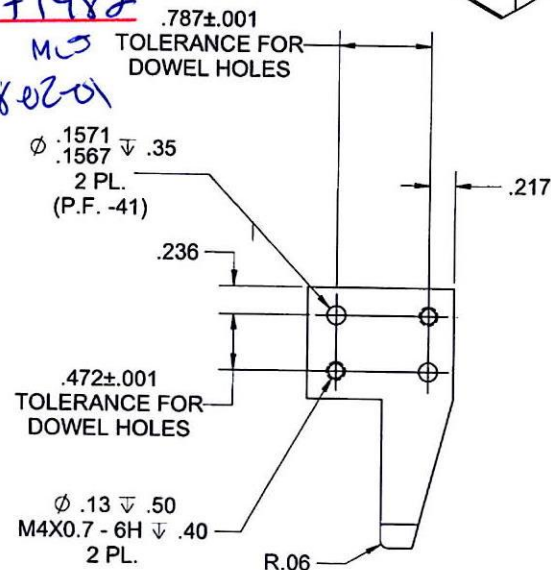
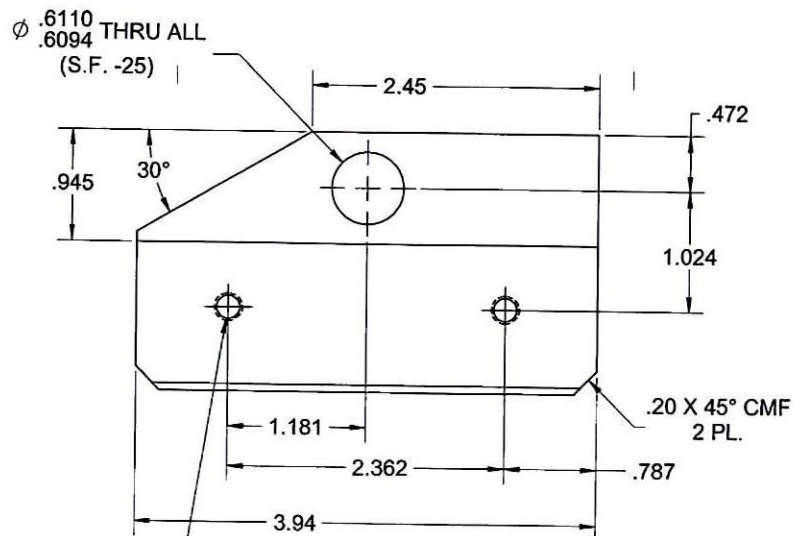
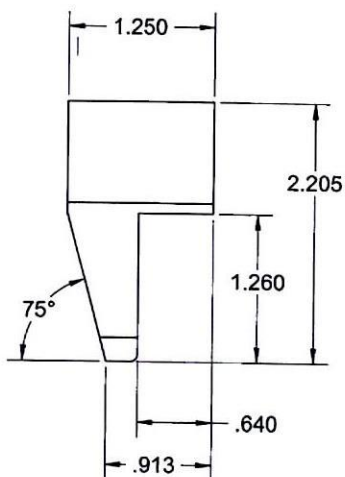
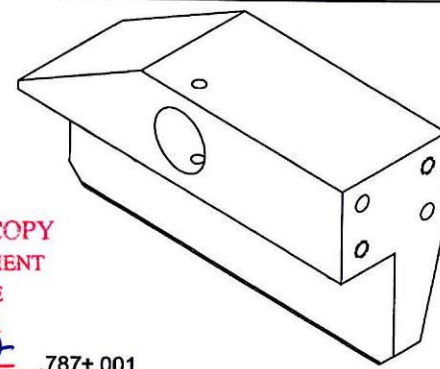
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171482



- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) FINISH: CLEAR ANODIZE
 - 3) HEAT TREAT: N/A
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 1; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE T/N & S/N PER CAD FILE "RBE703A94-1130-01-27 LATEST REV, 0.010" DEPTH

RBE703A94-1130-01-27 TAB ADJUSTER BODY

DART AEROSPACE Newbury, Ontario, Canada	
TITLE TAB ADJUSTER BODY	
OWD NO.	RBE703A94-1130-01-27
DESIGN BY:	VM 8/28/2017
DRAWN BY:	VM 11/24/2017
CHECKED:	WM 11/30/2017
MFG. APPR:	WM 11/30/2017
APPROVED:	WM 11/30/2017
DATE:	11/24/2017
SCALE:	NTS
WEIGHT:	0.546LBS
SHEET 11 OF 17	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: <u>171482</u> Part No. <u>RBE703A94-1130-01</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Jan 31, 2018		
Description Work Order Deviation				Disposition					
- APPLY LOCKTITE 263 TO MATING SURFACES OF ITEM -33 AND -27 - ITEM -33 SHOULD NOT PROTRUDE PAST THE SURFACE OF ITEM -27 - DO NOT ENGRAVE S/N ON PART - ENGRAVE ITEM -31 TO A DEPTH OF 0.010" - ITEM 58 SHOULD BE J.W. WINCO #64F45A				THE DEVIATIONS ARE ACCEPTABLE FOR ALL RBE703A94-1130-01 MANUFACTURED AT REV K.					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☒	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER : _____							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039432**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039432
PO Date: 4/6/18
Due Date: 4/5/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171174	RBE350A93-3307-00-05	Hex Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	4/5/18	6 pcs	0 pcs	6 pcs	\$22.50/pcs	\$135.00
2	171482	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	4/5/18	6 pcs	0 pcs	6 pcs	\$9.16666/pcs	\$55.00
3	171484	RBE703A94-1130-01-31	Tab Adjuster Gauge Plate -Issue P/O to ATG: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	4/5/18	6 pcs	0 pcs	6 pcs	\$9.16666/pcs	\$55.00
4	170582	RBE350A94-3301-00	T/R Accelerator Support -Issue P/O to ATG: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	4/5/18	6 pcs	0 pcs	6 pcs	\$9.1666/pcs	\$55.00
Grand Total:										\$300.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/29/18 1:05 PM dart.tsimiklis.chrisoula

deleted previous items



Certificat de Conformité / Certificate of Compliance

(007993-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007993- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
29-Mar-2018		Aman				PO039432			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
2	RBE350A93-3307-00-05 Rev.	RBE350A93-3307-00-05 BLACK OXIDE FINISH MIL-C-13964 CLASS 1 MIL-C-16173 GRADE 4	OXIDE-BLACK CH	6	6	0	0	0	
3	RBE703A94-1130-01-27 Rev.	RBE703A94-1130-01-27 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0	
4	RBE703A94-1130-01-31 Rev.	RBE703A94-1130-01-31 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0	
5	RBE703A94-1130-01-03 Rev.	RBE703A94-1130-01-03 PARTS RETURNED	ANODIZE CH	6	6	0	0	0	
6	RBE350A94-3301-00 Rev.	RBE350A94-3301-00 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0	
7	RBE703A94-1130-01-09 Rev.	RBE703A94-1130-01-09 PARTS RETURNED	ANODIZE CH	6	6	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.